

CLAMP DEVICE AND CLAMP METHOD FOR
HEAT-TREATED ARTICLE

ABSTRACT

A heat treatment operation can be executed, suppressing a wave-shaped deformation at a non heat-treatment region of an article to be heat treated.

—To an elongated-shaped article to be heat treated (10) to which a raised portion (11) extending in the longitudinal direction is formed, a hardening region, as being a heat-treated region defined to be extended extend in a longitudinal direction at a part of the raised portion (11), and a non-hardening region, as being a non-heat-treated region defined to be extended extend in the longitudinal direction at flange portion (13), and other parts of the raised portion (11) are arranged side by side in a width direction orthogonal to the longitudinal direction. The flange portion (13) is clamped by a first and a second clamping means clamp (22), (23) arranged in the longitudinal direction, and one first clamping means clamp (22) is a tight clamping means clamp for holding fixedly the flange portion (13) and a plurality of second clamping means clamps (23) are loose clamping means clamps for clamping loosely the flange portion (13), allowing the article to be heat treated (10) to be convex on the side of the heated hardening region.